

# Work Order ID 68160

Thursday, April 07, 2011 11:11:32 AM



Page 1

Item ID: D4314-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Shim

Start Date: 4/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-04-7

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4314

A

100

0.00



FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D4314

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

6061 .125

110

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

120

0.00



QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

*Sulovator*

B11-4-7

*(8)*

B11-4-7

(18)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68160**

Thursday, April 07, 2011 11:11:33 AM



Page 2

Item ID: D4314-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Shim

Start Date: 4/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00				(8X)			
Small Fab	Memo	0.00							
Small Fab	COUNTER SINK AS PER DWG								
150  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00				(x8)			
160  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

⇒ m-l 11/04/11

Subonly

x8 - d 11/11/12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 68160**

Thursday, April 07, 2011 11:11:33 AM



Page 3

Item ID: D4314-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Shim

Start Date: 4/7/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 BL 11-4-12

180

Identify as per dwg &amp; Stock Location: B7E

0.00



Packaging

Memo

0.00

Packaging

11/4/12 8x P

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/13 J

11-04-13  
6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 07, 2011 11:11:39 AM

Page 1

Work Order ID: 68160



Parent Item: D4314-1



Parent Item Name: Shim



Start Date: 4/7/2011

Required Date: 4/14/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 11-02-02 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	143.9000	0.019	0.16			
													
6061-T6 .125 Sheet													

KB11-4-7

Location

Loc Qty

Loc Code

MAT021

143.9

113608

119.9

116700

24

113608

8

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

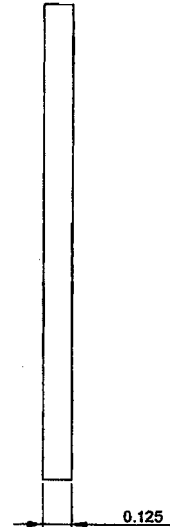
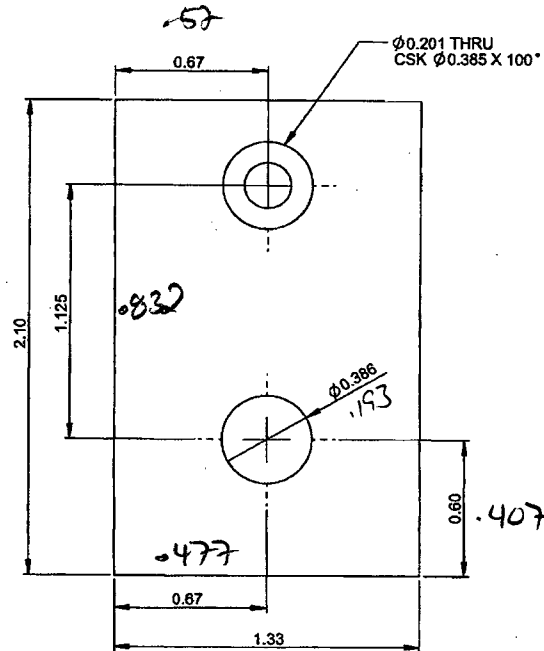
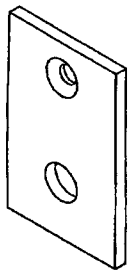
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68160

*BR 11-04-7*

**D4314-1 SHIM**

**RELEASED**  
2011-02-03  
*MB*

**NOTES:**

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.125)  
OR  
ALUMINUM 8061-T8/T62 SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11  
AMS 4025 OR ASTM B209 (REF DART SPEC M6061T6S.125)  
OR  
ALUMINUM 5052-H32 SHEET PER QQ-A-250/8 OR AMS-QQ-A250/8  
AMS 4016 OR ASTM B209 (REF DART SPEC M5052H32S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

A NEW ISSUE		SC	11.01.13
REV.	DESCRIPTION		BY DATE
DESIGN	SC	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4314	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SHIM	NTS
DATE	11.01.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

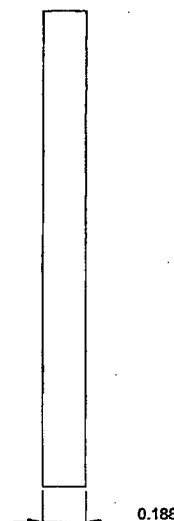
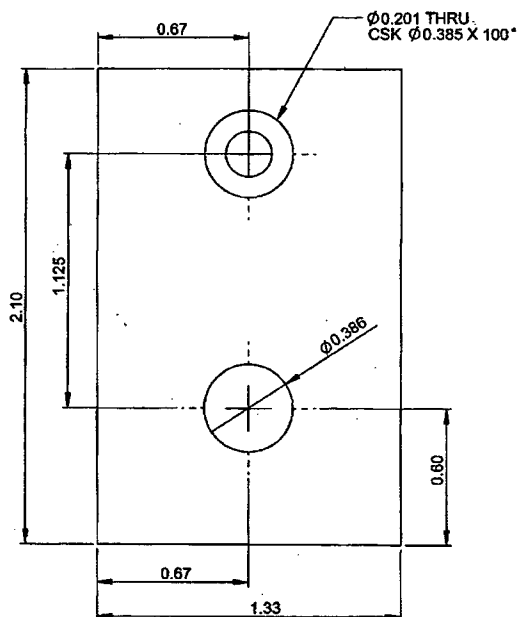
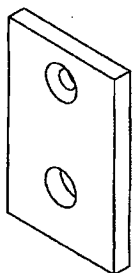
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



*W/068160*

**D4314-3 SHIM**

**RELEASED**  
2011-02-01  
*W*

**NOTES:**

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.188) OR ALUMINUM 6061-T6/T62 SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11 AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.188) OR ALUMINUM 5052-H32 SHEET PER QQ-A-250/8 OR AMS-QQ-A-250/8 AMS 4016 OR ASTM B209 (REF DART SPEC M5052H32S.188)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

DESIGN	SC	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	<i>JP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JP</i>	<b>D4314</b>	SHEET 2 OF 2
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	<b>SHIM</b>	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng				Sign & Date

**NOTE:** Date & initial all entries

